Split

Work Order ID 83043-1

83043

April-12-12 1:01:56 PM

Item ID: D3414-041

Revision ID:

Item Name: Lug Assembly

Start Date: 12/04/2012 **Start Qty:** 40.00 *40*

Required Date: 26/04/2012 **Req'd Qty:** 40.00 *40*

Reference:

Accept *N900040100*

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Run Start *NR1*

Stop *NR2*

Approvals: Process Plan: MLJ Date: 12/04/12 Tooling: Date:

QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D3414	Rev C								
100		0.00				40			JM 12-4-14
100		0.00							
Waterjet	**Memo**								
FLOW CNC Waterjet	1-Cut as per Dwg D3414-1 Dwg Rev: C Prog Rev: C								
204 0.100	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00				40			JM 12-4-14
110		0.00							
QC	**Memo**								
Quality Control									

Work Order ID 83043

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Item ID: D3414-041 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Lug Assembly

Start Date: 12/04/2012 **Start Qty:** 40.00 *40*

Required Date: 26/04/2012 **Req'd Qty:** 40.00 *40*

Reference:

Cust Item ID:

Customer:

Run Start *NR1*

Stop *NR2*

Approvals: **Process Plan:** **Date:** **Tooling:** **Date:**

QC: **Date:** **SPC (Y/N):** **Date:**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00 Satisfactory				counts (40)			
130 *130* Brake NC Brake NC	Memo 1-Deburr 2-Form using DT8254 as per Dwg D3414	0.00 0.00 SB satisfactory				40			
140 *140* Large Fab Large Fab	Memo 1- Weld using location Jig DT9625 as per Dwg D3414 A/R S.S welding rod Batch M114509	0.00 0.00				18			EC 12-4-24.

Work Order ID 83043

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Accept *N9000040100*

Setup Start *NS1*

Stop *NS2*

Item ID: D3414-041

Revision ID:

Item Name: Lug Assembly

Start Date: 12/04/2012 **Start Qty:** 40.00 *40*

Required Date: 26/04/2012 **Req'd Qty:** 40.00 *40*

Reference:

Cust Item ID:

Customer:

Run Start *NR1*

Stop *NR2*

Approvals: **Process Plan:** Date:

QC: Date:

Tooling: Date:

SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours
150	QC9- Inspect visual per QSI004- Fusion Welds	0.00
150 QC Quality Control	Memo	0.00
160	QC5- Inspect part completeness to step on W/O	0.00
160 QC Quality Control	Memo	0.00
170	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00
170 Powdercoat Powder Coating	Memo START TIME: 11:20 OVEN TEMPERATURE: 400°F FINISH TIME: 11:50	0.00

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
			18X			GC 12.04.24

Sakulas

48

18 X 0

M-L 12/04/26

M121134

Work Order ID 83043

83043

April-12-12 1:01:56 PM

Item ID: D3414-041
Revision ID:
Item Name: Lug Assembly
Start Date: 12/04/2012 **Start Qty:** 40.00 *40*
Required Date: 26/04/2012 **Req'd Qty:** 40.00 *40*
Reference:

Accept *N900040100* Setup Start *NS1*
Stop *NS2*

Cust Item ID:
Customer:

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** **Date:**
QC: **Date:**

Tooling: **Date:**
SPC (Y/N): **Date:**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 *180* QC Quality Control	QC3- Inspect Part Finish	0.00				18 x	0		MuLo4/12
	Memo	0.00							
190 *190* Packaging Packaging	Identify as per dwg & Stock Location: 479	0.00				18			12/04/27 JB
	Memo	0.00							
200 *200* QC Quality Control	QC21- Final Inspection - Work Order Release	0.00							12/4/30
	Memo	0.00							12-04-27

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83043
D3414-041

ork Order ID: 83043
arent Item: D3414-041
arent Item Name: Lug Assembly

Start Date: 12/04/2012
Start Qty: 40.00
Required Date: 26/04/2012
Required Qty: 40.00

Comments: IPP A05.09.13New issueKJ/JLM

Component Item ID/ tem Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S12GA		Purchased	No			100	sf	119.3300	0.455 **	6.2			

M304S12GA
304/316 0.100" Sheet

Location	Loc Qty	Loc Code
MAT019	119.33	M3062
113062	105.1	
113077	14.23	(40)

D3414-3	Manufactured	No			140	Each	0.0000	1 **

D3414-3
Lug

B76228 ~~[illegible]~~ X18. 12-4-23

12-4-12

DART AEROSPACE LTD	Work Order:	83043
	Part Number:	D3414-1
Description: Lug Bracket		
Inspection Dwg: D3414 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [X] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.313	+0.006/-0.001	0.315	✓		VC-1	HB-02
1.19	+/-0.030	1.187	✓		VC-1	HB-02
1.00	+/-0.030	1.005	✓		VC-1	HB-02
3.38	+/-0.030	3.363	✓		VC-1	HB-02
5.350	+/-0.010	5.349	✓		VC-1	HB-02
6.23	+/-0.030	6.216	✓		VC-1	HB-02
2.500	+/-0.010	2.502	✓		VC-1	HB-02
0.37	+/-0.030	0.370	✓		VC-1	HB-02
0.100	+/-0.010	0.102	✓		VC-1	HB-02

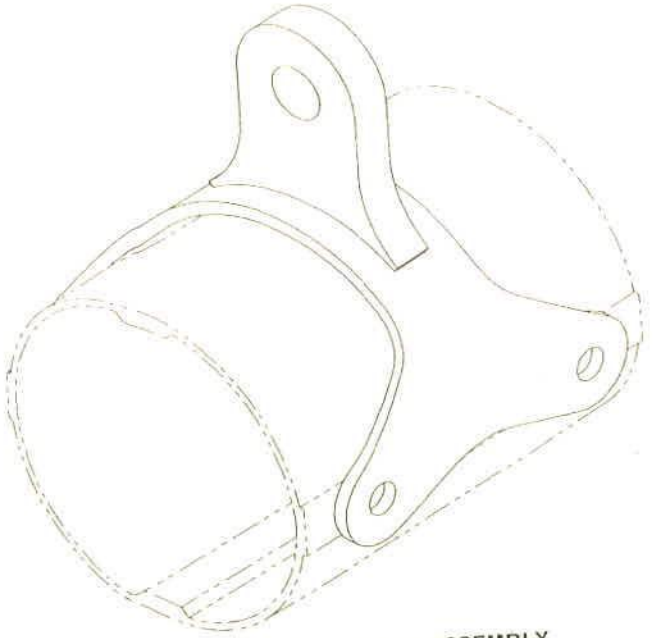
Measured by:	JM
Date:	12-4-14

Audited by:	C
Date:	12/04/16

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.02.28	New Issue P/O D3414-041	KJ/DD	
B	09.05.27	Dimensions updated per Dwg Rev B	KJ	
C	09.10.16	Dwg Rev updated to Rev C	KJ	

ITEM No.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D3414-041	LUG ASSEMBLY
2	1	D3414-1	LUG BRACKET
3	1	D3414-3	LUG



D3414-041 LUG ASSEMBLY

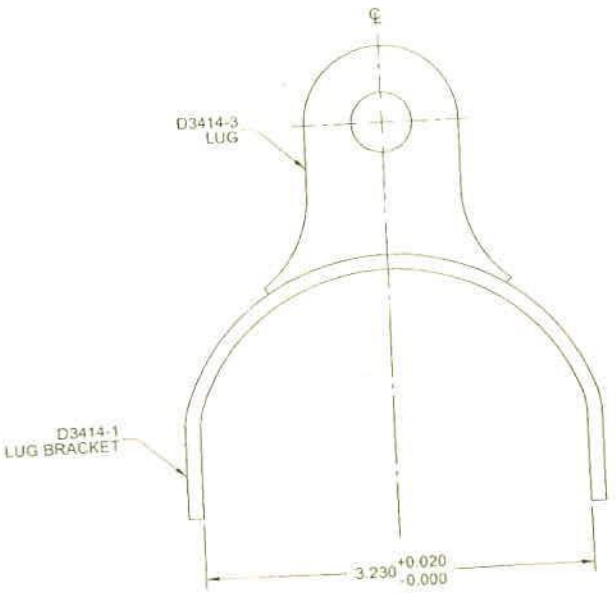
RELEASED

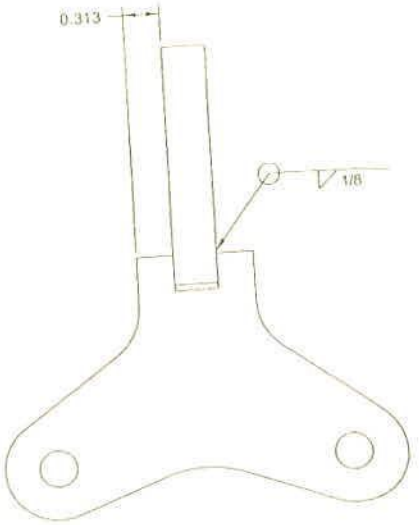
REV.	DESCRIPTION	BY	DATE
C	BREAK SHARP EDGES FOR -3 NOW 0.030-0.060 WAS 0.010-0.030 (ZN A7-3)	CP	09.06.17
B	DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND TRANSFERED TO "B" SIZE BORDER STANDARDS AND TRANSFERED TO "B" SIZE BORDER FLAT PATTERN FOR -1 INCREASED IN LENGTH TO PREVENT FOULING AT INSTL (SEE PAR198). FLAT SPOTS REMOVED FROM -1 (PART NOW "U" SHAPED) FOR EASE OF MANUFACTURE. B7.3 ADDED TOLERANCE TO 3.230 DIM. C2-3 1.12 DIM WAS 1.20.	AJS	08.09.23
A	NEW ISSUE	CP	05.03.16

DESIGN	CP	DART AEROSPACE LTD
DRAWN	CP	HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D3414 REV. C
MFG. APPR.		TITLE LUG ASSEMBLY SHEET 1 OF 3
APPROVED		SCALE NTS
DE APPR.		
DATE	09.06.17	

NOTES:
1) MATERIAL: N/A
2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3414-041" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.52 lbs

8303



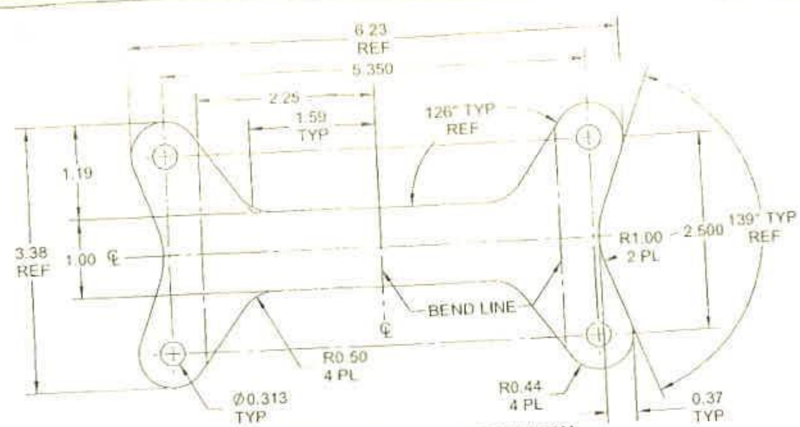


D3414-041 LUG ASSEMBLY

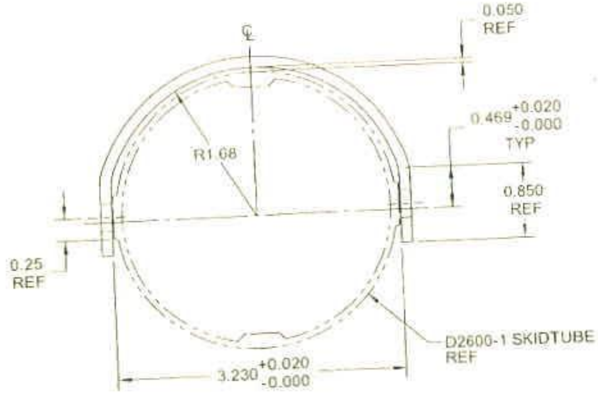
RELEASED

DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	CP	DRAWING NO. D3414 REV. C
CHECKED		SHEET 2 OF 3
MFG. APPR.		TITLE LUG ASSEMBLY SCALE NTS
APPROVED		
DE APPR.		
DATE	09.06.17	

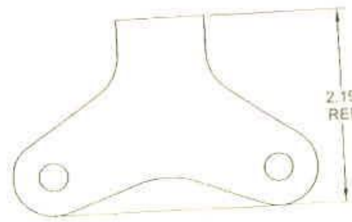
83043



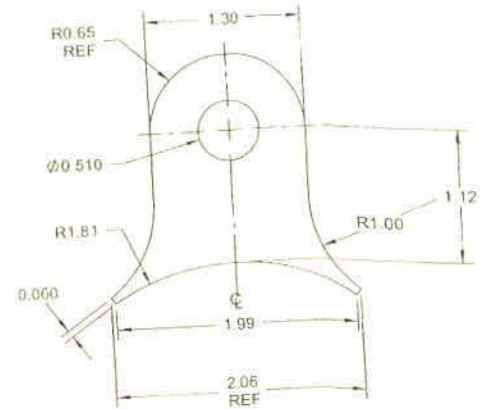
D3414-1F LUG BRACKET FLAT PATTERN



D3414-1 LUG BRACKET



SIDE VIEW FOR REF ONLY



D3414-3 LUG

RELEASED 09/06/06 NM

NOTES:
1) MATERIAL: -1: AISI 304/316 STAINLESS STEEL SHEET, 12 GAUGE (0.100 THICK)
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304S12GA

-3: AISI 304/316 STAINLESS STEEL PLATE
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304S

2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: -1: 0.010 TO 0.020 MAX
-3: 0.030 TO 0.060 MAX (C)
6) IDENTIFICATION: N/A
7) WEIGHT: N/A

DESIGN	CP
DRAWN	CP
CHECKED	
MFG. APPR.	
APPROVED	
DE APPR.	
DATE	09.06.17

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO: D3414 — REV. C — SHEET 3 OF 3
TITLE: LUG ASSEMBLY — SCALE: NTS